

Date: Sunday, 12/4/2005 12:43:13 PM
Linda Lachelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25085A
Estimate Number : 10163
P.O. Number : N/A
This Issue : 12/4/2005 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 25084A
Written By : SEE COMMENT BELOW
Checked & Approved By :
Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Part Number : D206642241
Drawing Number : D2650 REV D1
Project Number : N/A
Drawing Revision : D1
Material : N/A
Due Date : 1/20/2006 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 D2620 Bent 206 Skidtube

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2620 Bent Tube 3" OD B24497 DP 05-12-14 ①

2.0 D32861 Doubler

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3286-1 Doubler B24206 BE 06-01-03 ①

3.0 D2647 Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2647 Fwd Cap B20535 BE 05-12-19 ①

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube DP 05-12-14 ①

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 DP 05-12-14

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

WORK ORDER CHANGES

PROCEDURE CHANGE					By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 111 PAR #: Fault Category: NCR: Yes No DQA: Date:
 QA: N/C Closed: Date:

WORK ORDER NON-CONFORMANCE (NCR)									
NCR:									
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Seq. # Machine Or Operation:

Description:

Qty Part Number Description Batch

A/R Aluminum Rod m15855 / m18901 BE 05-12-19 ①

4-Grind weld flush to cap on top surface only. BE 05-12-19 ①

5-Cut Aft end as per dwg 2650 from front of tube and Deburr DP 05-12-22 ①

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 BE 05-12-23 ①

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. BE 05-12-23 ①

8-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. BE 06-01-03 ①

9- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. BE 06-01-03 ①

10-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. BE 06-01-03 ①

11-Remove and Deburr D3286-1 doubler BR 06-01-03 ①

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 BE 06-01-03 ①

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder BE 06-01-03 ①

14-Remove indexing edge using DT8741 as per Dwg D2650 DP 06-1-12 ①

15-C'sink GHW rivet holes as per Dwg D2650 BE 06-01-17 ①

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650 BE 06-1-19 ①

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. BE 06-1-19 ①

3-Deburr tube and blow out chips from inside the tube BE 06-1-19 ①

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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RM 06-01-19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-19

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

BE 06-01-20

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

BE 06-01-20

3-Deburr and blow out all chips from inside the tube

BE 06-01-20

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-01-22

11.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

M19491

pmc 06-01-23

12.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3

Web

B24498

pmc 06-01-24

1

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

pmc 06-01-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-01-24 Time: 8:45

Finish Date: 06-01-24 Time: 7:30

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m19597

Sikaflex expire date: 06-06-20

pm 06-01-24

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-26

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer *B 24200 BE 06-01-31*

16.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer *B 24711 BE 06-02-06*

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *m15855 BE 06-01-31*

2-Grind welds flush as per Dwg D2650. *BE 06-01-31*

3-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Debur *pm 06-02-06*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each

WORK ORDER CHANGES

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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod 10VE BE 06-02-06 (1)

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets m18548 Pm 06-02-07 (1)

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets m7808 Pm 06-02-07 (1)

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate B21103 Pm 06-02-07 (1)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm 06-02-07 (1)

22.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

a.m 06-07-19 (1)

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

am 8-6-07-20 (1)

25.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

B25904

26.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

B27074

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B27075

28.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B21148

29.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B24417

DL 06/07/23 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS41032-130

Inserts

M19393

or (see QSI 017)

31.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

M101291

32.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

M19551

33.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

B25865

34.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings

B25978

DL 06/07/23 d

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M6874

36.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer M1151

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M101183

Sikaflex expire date: 11/06

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650.
Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

DC
06/07/23 (1)

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

06-07-23 (1)

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B25381

DC 06/07/23 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25085A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M19551

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M101291

DL 06/07/23 ①

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M101123

Sikaflex expire date: 11/09

DL 06/07/23 ①

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M101667

FC 06 07 24 ①

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

06/07/25 ①

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/28 ①

Job Completion



06.07.28

W/O:		WORK ORDER CHANGES						
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